Work Orde		n	4072-1	*107	7804*			Page 1
Revision ID: tem Name: Start Date:	D4072-1 Airframe Hing 10/03/13	Bee Start Qty: 8.00	107805	Accept 16 9 (3/10/0)	*N900040	100*	Setup	Start *NS1* Stop *NS2*
Required Date: Reference: Approvals:	Process Pla	Req'd Qty: 8.00	Date: 13-10-0	73 Tooling:	· Date:			Start *NR1*
Sequence ID/ Work Center II		Operation Description	Date:	SPC (Y/N): Set Up/ Run Hours	Tool ID Tool #	Plan Ac Code Qt	ccept Reje	*NR2*
Draw Nbr		ision Nbr		Kun Hours		Code Qi	y Qiy	Number Stamp
00 * 1 0 0 * Bandsaw leaspa Bandsew		Cut blanks as per folio Memo CUT 1.250	P" LONG	0.00	S\$12-10-0	7	le 9	
105 *1∩5* HAAS 1 HAAS CNC vertical	machine #1	Memo Mill as per Dwg Rev: Folio Rev:	Dwg an Folio FΛ938	0.00	SS 13-10-07 27 13-10-0	ns (x	10	

Deburr

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DQA:	Date:	
		 -

WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Water Jet Rework Skid-tube Crosstube Quality Machining Prod. Eng. Coor. Small Fab Scrap Part No. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Action Description of work order update Sign & Initial Root Verification Qty or Non-conformance Chief Eng Description Date QC Inspector Cause Date Step Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Grain Ovalized Pressure/Forced Bend Temperature/Cure BOM/Route Over/Under tolerance Hardware Centre Not Concentric to O/S Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Contamination Maintenance Part Moved Cuffs Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short **Drill Holes** Offset Ripples in Bend

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde				*107	7804*				Page 2
Revision ID:	D4072-			Accept	*N90004	4010¢)* s	Setup Star Stop	11117
Start Date: Required Date: Reference:	10/03/13 10/08/13		*8* *8*		Cust Item ID: Customer:				
Approvals:		s Plan:			Date:Date:		R	tun Star Stoj	"NRT"
Sequence ID/ Work Center II 110 *110* QC Quality Control)	Operation Description QC2- Inspect parts off m	nachine FAI/FAIB	Set Up/ Run Hours 0.00	Tool ID To	ool# Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
120 *120* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00	W 13/10/08		Ple	B	
150 *150* HandFinish		Chemical Conversion Co	oat per QSI005 4.1	0.00			16	: K	3-D.9

Hand Finishing

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					-
												QA Closed:	Da	te:	
Work Orde	oř.				,	DISPOSITION				AGAINS'	T DE	PARTMENT	/PROCESS		
Part I	No. _.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fal Finishin Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
04			1	1	Danari		_ 	Initial	Λ.	ction		Cian 9			
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	1	nief Eng		cription		Sign & Date	Verificatio	n	QC Inspector
Doc/Data	П	Date	Step	Qty		or Non-comormance	+	nei chg	Desc	.iiption		Date	Verificació		QC IIISPECTOI
Equip/Tooling															
Operator Material	\vdash					·									
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Setup Other	\vdash														
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			<u> </u>	<u>.L</u>			FAUI	LT CATE	GORY						
Landi	ing (Gear				General									
	Ť	Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	/Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs			[.	Contamination		Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		-
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge		Other
		Ripples ir	n Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Orden October - 03 - 13		7804		*10	7804*						Page 3
Item ID: Revision ID:	D4072-1			Accept	*N900	040	100°	k Setu	p Start Stop	*NS	1*
Item Name:	Airframe Hing	ge							Stop	*NS	ク*
Start Date:	10/03/13	Start Qty: 8.00	*87	k	Cust Item I	D:					
Required Date: Reference:	10/08/13	Req'd Qty: 8.00	*8	*	Customer:						
Approvals:	Process Pla	n:	Date:	Tooling:	De	ate:		Run	Start	*NR	1*
Approvais.	QC:	114.	Date:			ite:			Stop	*NR	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#		Accept R Oty Q	-	Reject In	isp. tamp
*160 *160* Powdercoat Powder Coating	128	White Gloss(Ref.4.3.5.2 Memo) per QS1005 4.3-Stee	5/400/11/n	ne 1971	りた	16	XD 1,	MH	13/1	0/10
W \\	しりフェ	QC3- Inspect Part Finish	ı	CinoboSh 71	merg	~40					
170 QC Quality Control		Memo		0.00	·			161	<u></u>	<u>IL 13</u>	116/10
180		Identify as per dwg & Ste	ock Location: 5TC	29] 0.00							
180 Packaging		Memo		0.00				16x _	DAS 28	13-10	-18

Packaging

				DQA:	Date:
NCD.	V / B	1-	MODE ODDED NON CONFORMANCE / HIDDATE		

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is	The	Skid-tube Machining ermoforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]	Large Fab	Composite		*Supplier	
Root				Descri	ption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data										:	
Equip/Tooling											
Operator [1									
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved		<u> </u>									
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Landir	ng Gear			_	General			_	⊣		-
	Bending				Bend	Grai	n		Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	_BOM/Route	Harc	ware		Over/Under		Temperature/Cure
,	Cracks			<u> </u>	Broken/Damaged	Insp	ection Incomplete		Part Incorre	—	Weld
	Crushed	Crimped		<u> </u>	Burrs	 	uctions Incomplete	:/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
·	Cuffs			L	Contamination	Mai	ntenance	<u> </u>	Part Moved		
	Heat Tre	at		L	Countersink	Misl	abeled		Positioned V	_	٦
	Inspection	n Strip in	Tube		Cut Too Short	Misr		L	Power Loss/	Surge	Other
	Ripples i	n Bend		L	Drill Holes	Offs					
<u>,</u>	Torque V	Vaves in I	Extrusio	n	Drawing	\vdash	of Calibration				
	Turning :	Sequence	:		Finish	Out	of Sequence				
	Wave/Tv	vist in Tu	be		Folio	Outs	ide Dimensions		_		

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Work Orde		7804		*107	7804*							Page 4
Revision ID:	D4072-1 Airframe Hin	ge		Accept	*N900	040	100)*	Setup	Start Stop	1 11	S1* S2*
	10/03/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	ID:			_	G		
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:			Run	Start	*N	R1*
••	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
1 QA QC Quality Control	1	QC21- Final Inspection -	Work Order Release	0.00	ŧ	·		<u>.</u> М	L J ,		1-10-	I <u>(</u>
•	,			·	i						4	<i>.()</i>

pl13-10-10

		DQA:	Date:	
NCR: Yes /	No WORK ORDER NON-CONFORMANCE / UPDATE			

NCR: Yes / No	WORK ORDER NON-CONFORM
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QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Quality Machining Small Fab Prod. Eng. Coor. Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Chief Eng Description Date Verification QC Inspector Qty or Non-conformance Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Ovalized Pressure/Forced Bending Grain Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Cracks Part Incorrect Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Maintenance Part Moved Cuffs Contamination Countersink Mislabeled Positioned Wrong Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube **Cut Too Short Drill Holes** Offset Ripples in Bend **Out of Calibration** Drawing Torque Waves in Extrusion **Turning Sequence Finish** Out of Sequence Wave/Twist in Tube Folio **Outside Dimensions**

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Picklist Print

October-03-13 9:05:28 AM

Work Order ID: 107804

107804

Parent Item:

D4072-1

D4072-1

Parent Item Name: Airframe Hinge

Start Date: 10/03/13

Required Date: 10/08/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD

REV:B DRAWING REV. CHANGE AS PER ECN 11-598

IPP 11-07-05 JFS

VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		mary Last ation Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50		Purchased	No	and solders.	100	f	18.1200	0.104	1			-

M6061T6B1 000X02 500

6061-T6 Bar 1.00 x 2.50

Location Loc Qty Loc Code MAT003 18.12 124443 6.12 1.8331 125386 12

1.833'

Sf 13-10-07

			MORY ORDER MON CONFORM
NCR:	Yes /	No	WORK ORDER NON-CONFORMA

	DQA:	Date:
ORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Da	te:	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. NCR No.				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
Root Descri			Descri	ption of work order update Initial Action		ction	Sign &						
Cause	Date	Step	Qty		or Non-conformance	1	ef Eng		cription	Date	Verificatio	n	QC Inspector
Doc/Data		<u> </u>											············
Equip/Tooling								1					
Operator								I					
Material								I					
Setup								I					
Other	7							ļ					
Process													
Supplier								1					
Training						1		1					
Unapproved						ł		<u> </u>					
					F	AULT	CATE	GORY					
Landin	g Gear				General					_			·
	Bending				Bend		Grain			Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	LJ ¹	Hardwa	re		Over/Under	tolerance	Цī	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	ct	山	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	∐\	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved			
[Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong		
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge		Other
	Ripples in	n Bend			Drill Holes	\square	Offset						
	Torque V	Vaves in E	Extrusio	n [Drawing	\square	Out of C	Calibration					
	Turning S	Sequence			Finish	\square	Out of S	Sequence					
Wave/Twist in Tube Folio			he		Folio	1 1	Outside	Dimensions					

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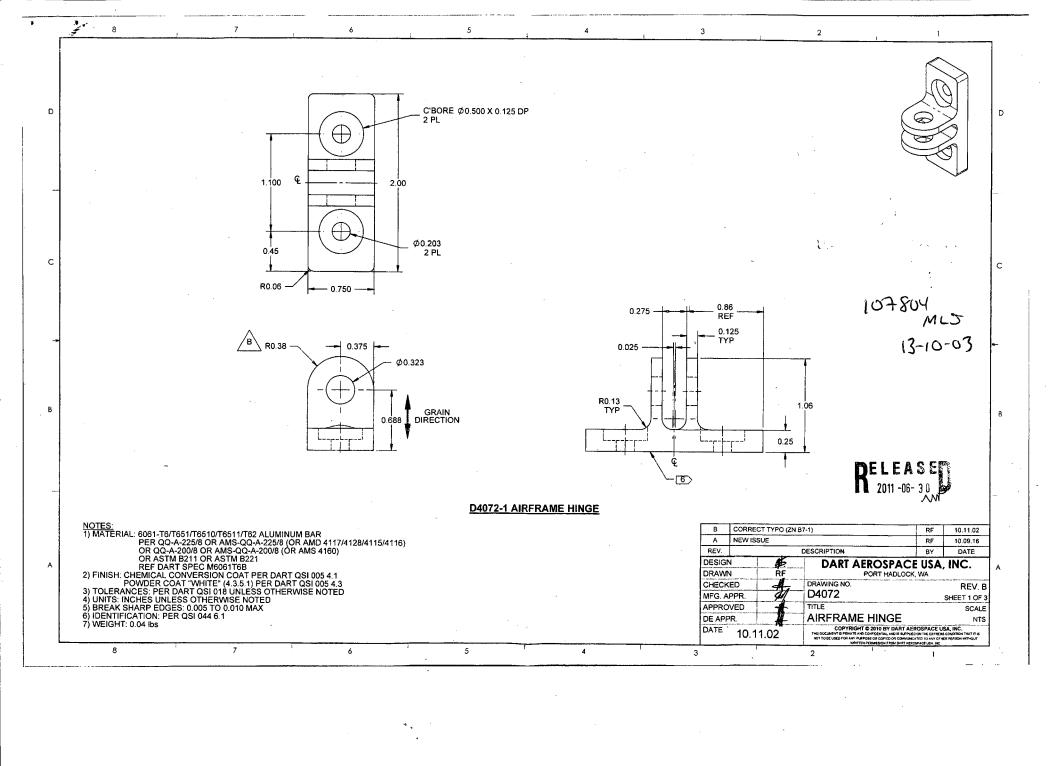
DART AEROSPACE LTD	Work Order:	107804
Description: Airframe Hinge	Part Number:	D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

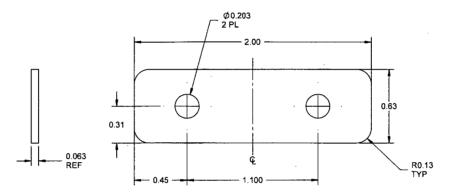
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	.503X.126	/		SL08	VerN
2.00	+/-0.030	2.001				
Ø0.203	+0.005/-0.001	.205				
0.750	+/-0.010	.751				
R0.06	+/-0.030	060	1		had g	augl
0.45	+/-0.030	.4485				•
1.100	+/-0.010	1.100				
R0.38	+/-0.030	.380			Rad ga	ug-l
0.375	+/-0.010	3745			V	
0.688	+/-0.010	e686				
0.275	+/-0.010	.275				
R0.13	+/-0.030	.125			had g	augl
0.25	+/-0.030	.250				
1.06	+/-0.030	1.062				
0.125	+/-0.010	e124				
0.86	+/-0.030	.865			Height	yauge Vein
Ø0.323	+0.005/-0.001	.324			5608	Vein
						· ·

	ρν				
Measured by:	#1	Audited by:	Onl	Preliminary Approval:	
Date:	13-10-07	Date:	13/10/08	Date:	

Rev	Date	Change	Revise	d by	Approved
Α	11.06.26	New Issue	KJ	10	
В	11.10.13	Dimension 0.25 removed	KJ	181_	
				"//	u ·



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D4072-3 AIRFRAME HINGE BACKING PLATE

NOTES: 1) MATÉRIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 OR ASTM B209
REF DART SPEC M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

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Α

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NOT TO BE USED FOR ANY PURPOSE OR CONFIDENCE CONCITION. DATE 10.11.02

DESIGN

DRAWN

CHECKED

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DRAWING NO.

2

DART AEROSPACE USA, INC.

SCALE NTS

REV. B

SHEET 2 OF 3

3 D D Ø0.45 -Ø0.196 Ø0.313 С -0.020 x 45° CHAMFER R0.01 0.230+0.015 В Œ - 0.060^{+0.000} **D4072-5 BUSHING** NOTES: 1) MATERIAL: AISI 303 STAINLESS STEEL BAR REF DART SPEC, M303B DESIGN DART AEROSPACE USA, INC.
PORT HADLOCK, WA REF DART SPEC. M303B
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.004 lbs DRAWN RF DRAWING NO. CHECKED REV. B D4072 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE AIRFRAME HINGE

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